

**SPECIFICATION AMENDMENTS**

*Page 4, line 3:*

FIGURES 4A and 4B [[to 4C]] show a nozzle design according to the invention;

*Page 7, lines 11-14:*

The nozzle design, shown in Figures 4A and 4B ~~through 4C~~, preferably uses three concentric channels at the nozzle tip. The center one carries laser beam and shielding gas. The middle channel brings powder and shielding gas. There is an additional third channel ending with 16 orifices carrying the powder shaping shielding gas.